1. Scope

1.1 This specification covers five grades of high-strength low-alloy structural steel shapes, plates, sheet piling, and bars. Grades 42 [290], 50 [345], and 55 [380] are intended for riveted, bolted, or welded structures. Grades 60 [415] and 65 [450] are intended for riveted or bolted construction of bridges, or for riveted, bolted, or welded construction in other applications.

1.2 For applications, such as welded bridge construction, where notch toughness is important, notch toughness requirements are to be negotiated between the purchaser and the producer.

1.3 The use of columbium, vanadium, titanium, nitrogen, or combinations thereof, within the limitations noted in Section 5, is required; the selection of type (1, 2, 3, 4, or 5) is at the option of the producer, unless otherwise specified by the purchaser. (See Supplementary Requirement S90.)

1.4 The maximum thicknesses available in the grades and products covered by this specification are shown in Table 1.

1.5 When the steel is to be welded, a welding procedure suitable for the grade of steel and intended use or service is to be utilized. See Appendix X3 of Specification A 6/A 6M for information on weldability.

1.6 The values stated in either inch-pound units or SI units are to be regarded separately as standard. Within the text, the SI units are shown in brackets. The values stated in each system are not exact equivalents; therefore, each system is to be used independently of the other, without combining values in any way.

1.7 The text of this specification contains notes or footnotes, or both, that provide explanatory material. Such notes and footnotes, excluding those in tables and figures, do not contain any mandatory requirements.

1.8 For structural products produced from coil and furnished without heat treatment or with stress relieving only, the additional requirements, including additional testing requirements and the reporting of additional tests, of A 6/A 6M apply.

2. Referenced Documents

2.1 ASTM Standards:

A 6/A 6M Specification for General Requirements for Rolled Structural Steel Bars, Plates, Shapes, and Sheet Piling
A 36/A 36M Specification for Carbon Structural Steel
A 514/A 514M Specification for High-Yield Strength, Quenched and Tempered Alloy Steel Plate, Suitable for Welding

3. General Requirements for Delivery

3.1 Structural products furnished under this specification shall conform to the requirements of the current edition of Specification A 6/A 6M, for the specific structural product ordered, unless a conflict exists in which case this specification shall prevail.

3.2 Coils are excluded from qualification to this specification until they are processed into a finished structural product. Structural products produced from coil means structural products that have been cut to individual lengths from a coil. The processor directly controls, or is responsible for, the operations involved in the processing of a coil into a finished structural product. Such operations include decoiling, leveling or straightening, hot-forming or cold-forming (if applicable), cutting to length, testing, inspection, conditioning, heat treatment (if applicable), packaging, marking, loading for shipment, and certification.

Note 1—For structural products produced from coil and furnished without heat treatment or with stress relieving only, two test results are to be reported for each qualifying coil. Additional requirements regarding structural products produced from coil are described in A 6/A 6M.

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*a Summary of Changes section appears at the end of this standard.*
4. Materials and Manufacture

4.1 The steel shall be semi-killed or killed

5. Chemical Composition

5.1 The heat analysis shall conform to the requirements prescribed in Table 2 and Table 3.

5.2 The steel shall conform on product analysis to the requirements prescribed in Table 2 and Table 3, subject to the product analysis tolerances in Specification A 6/A 6M.

6. Mechanical Properties

6.1 Tensile Properties:

6.1.1 The material as represented by the test specimens shall conform to the tensile properties given in Table 4.

7. Keywords

7.1 bars; bolted construction; bridges; buildings; columbium-vanadium; high-strength; low-alloy; plates; riveted construction; shapes; sheet piling; steel; structural steel; welded construction
### TABLE 3  Alloy Content

<table>
<thead>
<tr>
<th>Type</th>
<th>Elements</th>
<th>Heat Analysis, %</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Columbium(^a)</td>
<td>0.005–0.05(^c)</td>
</tr>
<tr>
<td>2</td>
<td>Vanadium</td>
<td>0.01–0.15</td>
</tr>
<tr>
<td>3</td>
<td>Columbium(^b)</td>
<td>0.005–0.05(^c)</td>
</tr>
<tr>
<td></td>
<td>Vanadium</td>
<td>0.01–0.15</td>
</tr>
<tr>
<td>5</td>
<td>Columbium plus vanadium</td>
<td>0.02–0.15(^c)</td>
</tr>
<tr>
<td></td>
<td>Titanium</td>
<td>0.006–0.04</td>
</tr>
<tr>
<td></td>
<td>Nitrogen</td>
<td>0.003–0.015</td>
</tr>
<tr>
<td></td>
<td>Vanadium</td>
<td>0.06 max</td>
</tr>
</tbody>
</table>

\(^a\) Alloy content shall be in accordance with Type 1, 2, 3, or 5 and the contents of the applicable elements shall be reported on the test report.

\(^b\) Columbium shall be restricted to the following thicknesses and sizes unless killed steel is furnished. Killed steel shall be confirmed by a statement of killed steel on the test report, or by a report on the presence of a sufficient quantity of a strong deoxidizing element, such as silicon at 0.10 % or higher, or aluminum at 0.015 % or higher. See table below.

\(^c\) Product analysis limits = 0.004 to 0.06 %.

\(^d\) Product analysis limits = 0.01 to 0.16 %.

### Grades

<table>
<thead>
<tr>
<th>Maximum Plate, Bar, Sheet</th>
<th>Maximum Structural Shape Flange or Leg Thickness, in. [mm]</th>
</tr>
</thead>
<tbody>
<tr>
<td>Grades</td>
<td>Piling, Zees, and Rolled Tee Thicknesses, in. [mm]</td>
</tr>
<tr>
<td></td>
<td></td>
</tr>
<tr>
<td>42, 50, and 55</td>
<td>3/4</td>
</tr>
<tr>
<td>[290, 345, and 380]</td>
<td>[20]</td>
</tr>
<tr>
<td>[415 and 450]</td>
<td>[13]</td>
</tr>
<tr>
<td>60 and 65</td>
<td>1/2</td>
</tr>
<tr>
<td>[415 and 450]</td>
<td>[13]</td>
</tr>
</tbody>
</table>

### TABLE 4  Tensile Requirements\(^a\)

<table>
<thead>
<tr>
<th>Grade</th>
<th>Yield Point, ksi [MPa]</th>
<th>Tensile Strength, ksi [MPa]</th>
<th>Minimum Elongation, % in 8 in. [200 mm]</th>
<th>in 2 in. [50 mm]</th>
</tr>
</thead>
<tbody>
<tr>
<td>42 [290]</td>
<td>42 [290]</td>
<td>60 [415]</td>
<td>20</td>
<td>24</td>
</tr>
<tr>
<td>50 [345]</td>
<td>50 [345]</td>
<td>65 [450]</td>
<td>18</td>
<td>21</td>
</tr>
<tr>
<td>60 [415]</td>
<td>60 [415]</td>
<td>75 [520]</td>
<td>16</td>
<td>18</td>
</tr>
</tbody>
</table>

\(^a\) See specimen Orientation under the Tension Tests section of Specification A 6/A 6M.

\(^b\) Elongation not required to be determined for floor plate.

\(^c\) For wide flange shapes over 426 lb/ft [634 kg/m], elongation in 2 in. [50 mm] of 19 % minimum applies.

\(^d\) For plates wider than 24 in. [600 mm], the elongation requirement is reduced two percentage points for Grades 42, 50, and 55 [290, 345, and 380], and three percentage points for Grades 60 and 65 [415 and 450]. See elongation requirement adjustments in the Tension Tests section of Specification A 6/A 6M.
SUPPLEMENTARY REQUIREMENTS

Supplementary requirements shall not apply unless specified in the order or contract. Standardized supplementary requirements for use at the option of the purchaser are listed in Specification A 6/A 6M. Those that are considered suitable for use with this specification are listed by title:

- S18. Maximum Tensile Strength
- S30. Charpy V-Notch Impact Test for Structural Shapes: Alternate Core Location

In addition, the following supplementary requirements are suitable for use:

**S81. Tensile Strength**

S81.1 For Grade 50 [345] steel of thicknesses 3/8 in. [20 mm] and less, the tensile strength shall be a minimum of 70 ksi [485 MPa].

**S90. Type**

S90.1 The specific type of steel shall be as specified by the purchaser in the order or contract.

SUMMARY OF CHANGES

Committee A01 has identified the location of selected changes to this standard since the last issue (A 572/A 572M-03\(e^{1}\)) that may impact the use of this standard. (Approved April 1, 2004.)

1. Supplementary Requirement S32 has been added.
2. Table 3 has been revised to remove Type 4.

Committee A01 has identified the location of selected changes to this standard since the last issue (A 572/A 572M-03) that may impact the use of this standard. (Approved May 10, 2003.)

1. Tables 1, 2, and 3 have been revised.

Committee A01 has identified the location of selected changes to this standard since the last issue (A 572/A 572M-02) that may impact the use of this standard.

1. 1.8, 3.1, 3.1.1 (renumbered as 3.2), and Note 1 have been revised to be consistent with the terminology and requirements of Specification A 6/A 6M.
2. Table 1, footnote C was changed to 11 in. [275 mm].
3. Table 2, footnote F was changed to 11 in. [275 mm].

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